

Date: Wednesday, 03/09/2008 10:29:27 AM  
 User: Julie Lecocq

## Process Sheet

small

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 41736  
 Estimate Number : 10616  
 P.O. Number :  
 This Issue : 03/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D265631  
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2656 REV D  
 Previous Run : 27474 Project Number : N/A  
 Material : D  
 Due Date : 30/09/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : Julie Lecocq  
 Comment : Est: D 02.10.25 Re-format KJ  
 Est Rev:E 06-06-12 Now On Waterjet JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025 SHEET



Comment: Qty.: 0.4095 sf(s)/Unit Total : 4.9140 sf(s)  
 1010/1025/A21/6aA .040"SHEET  
 (M1010S20GA)  
 Batch: 108275 B 8-9-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2656  
 Dwg Rev: D  
 Prog Rev: D

B 8-9-15

2-Deburr if necessary

B 8-9-15

13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-9-15

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

50810616(13)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.  
 Identify as D2656-31.

50810616(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:29:27 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 41736

Part Number: D265631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8 oct 08/17* *(13)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: *10:30am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *11:00am*

*MF 08-09-17*

*(13)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*MF 08/09/17*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *P-20*

*MF 08-09-17*

*(13)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/17*

Job Completion



*MF 08-09-17*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

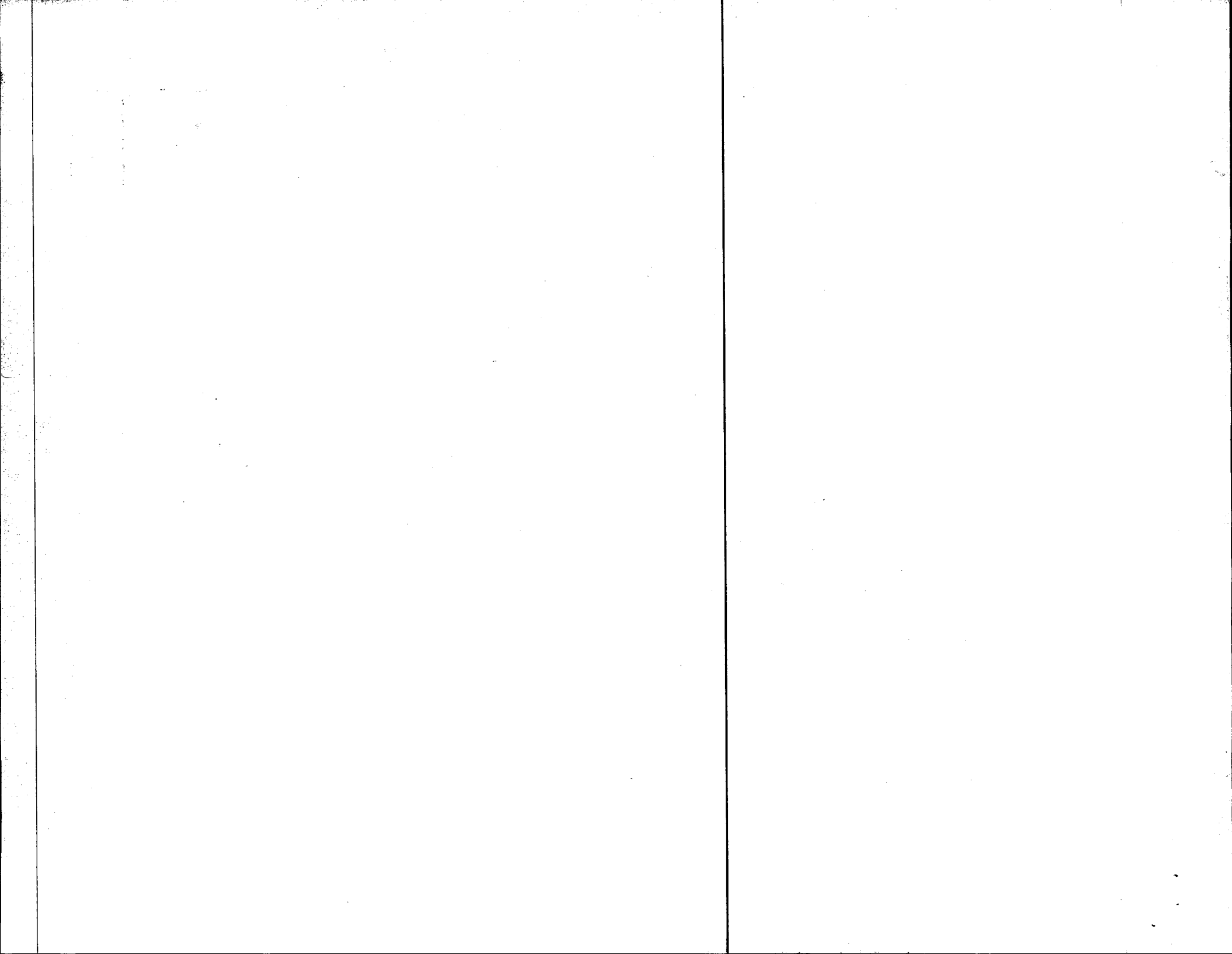
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

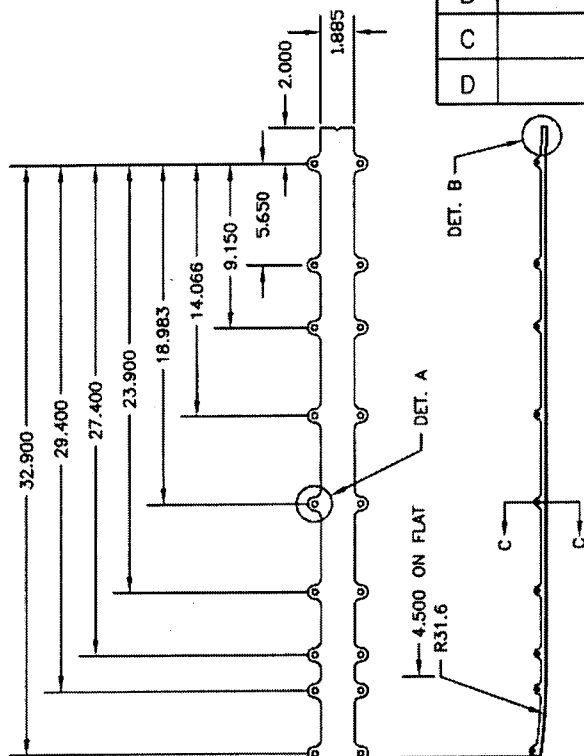




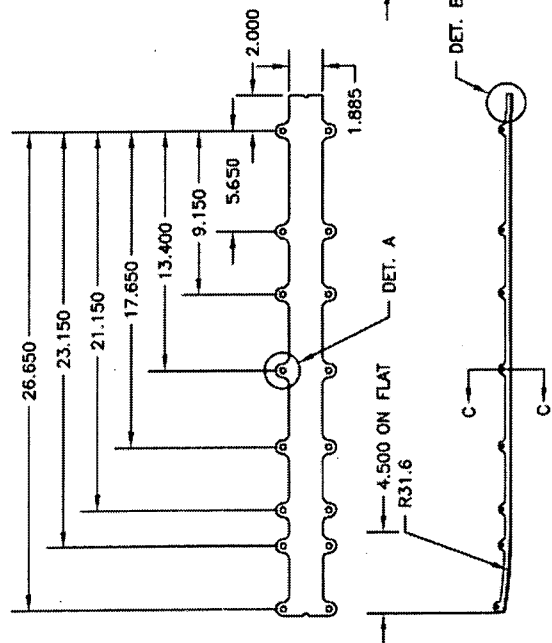


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

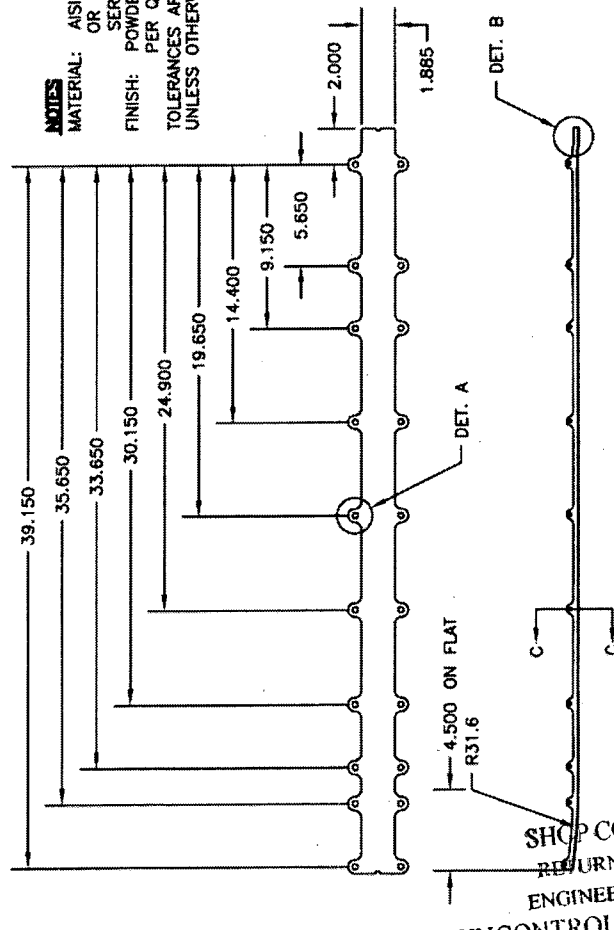
D2658-13



D2658-11



D2658-15



**NOTES:**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05-09-08

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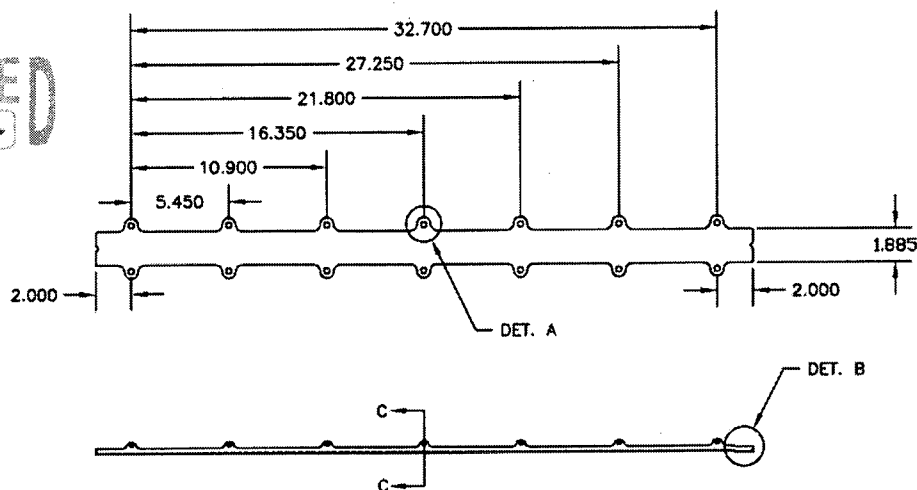
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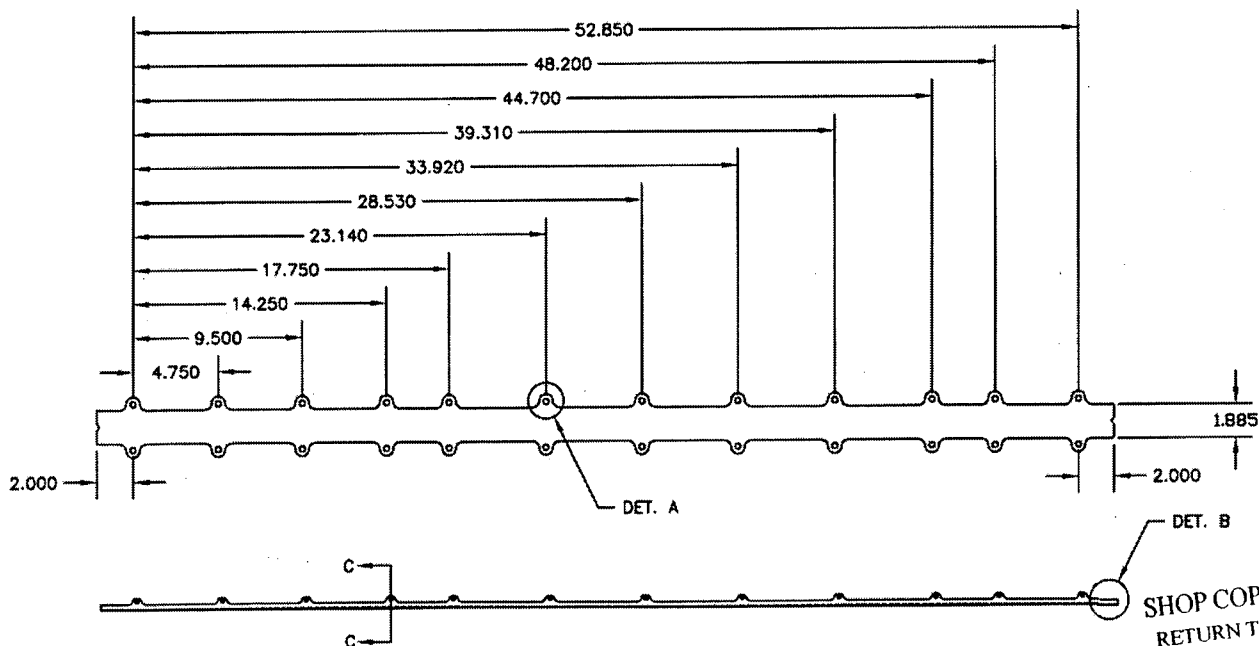
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED  
05.07.06

### D2656-21



### D2656-23



#### NOTES

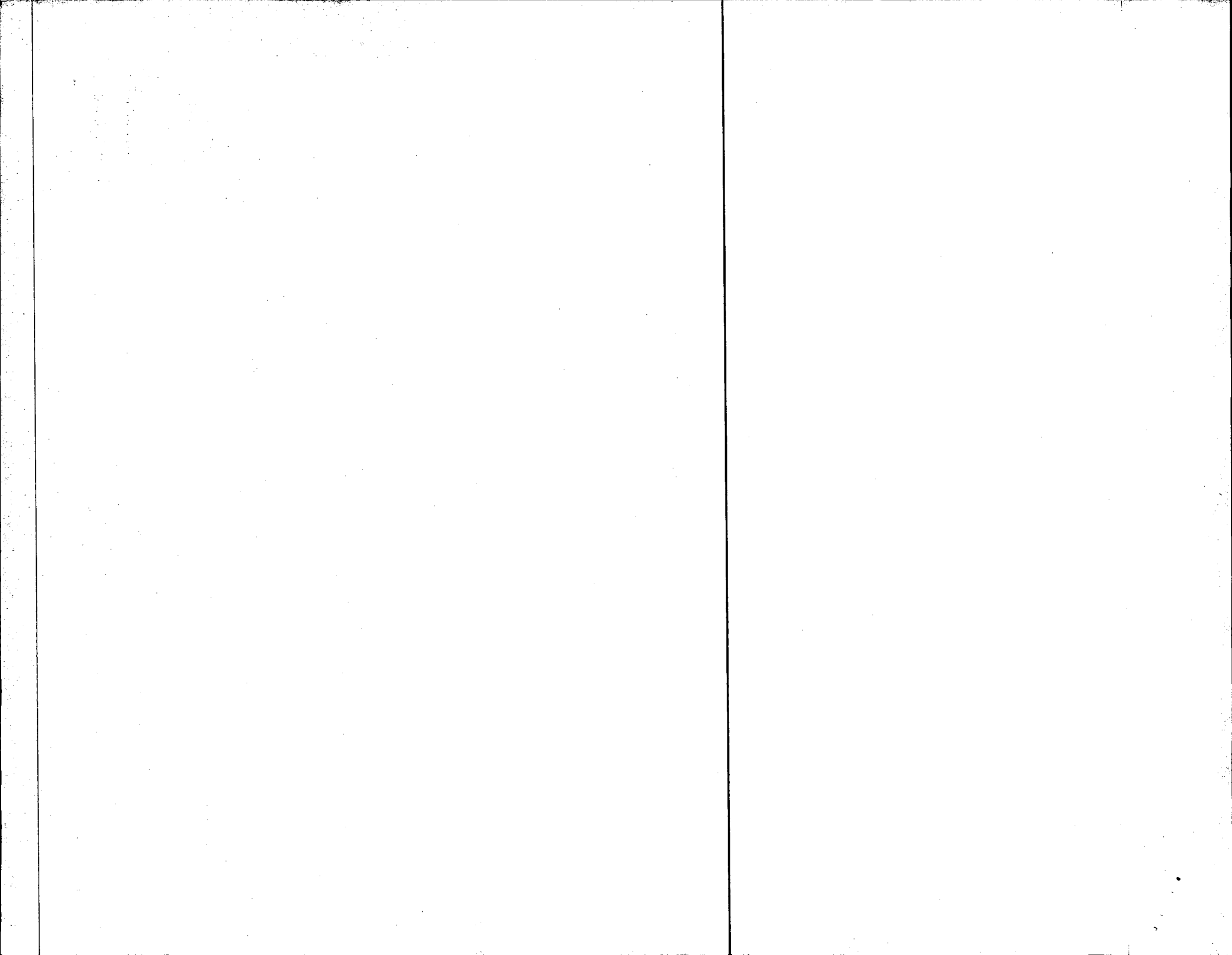
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SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
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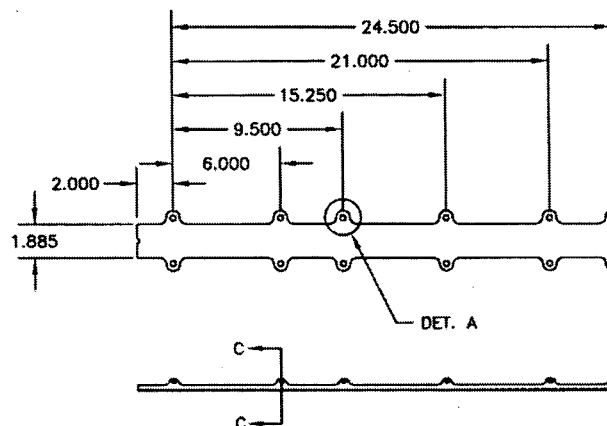




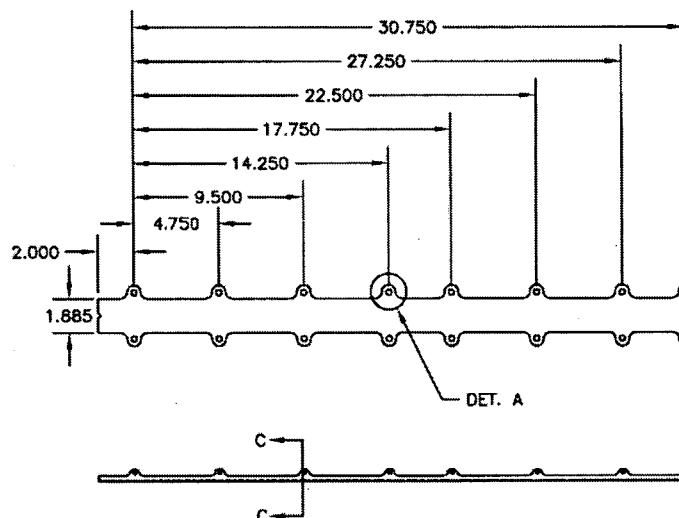


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656	SHEET 3 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE	1:10

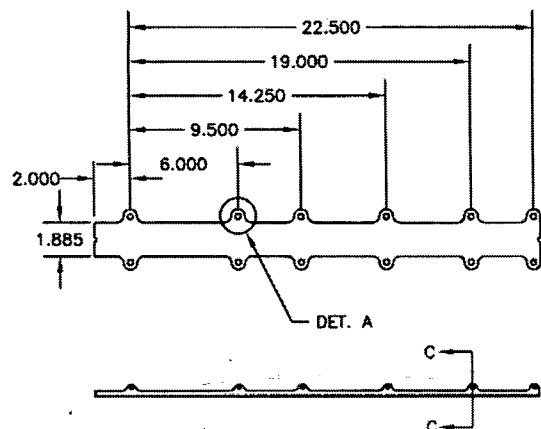
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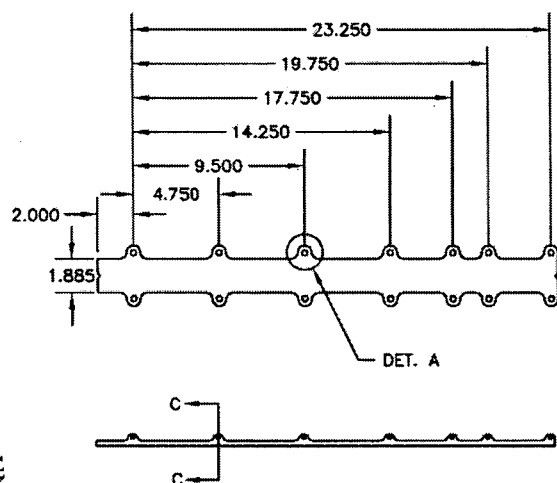
**D2656-37**



**D2656-31**



**D2656-35**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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FINISH: POWDER COAT, GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
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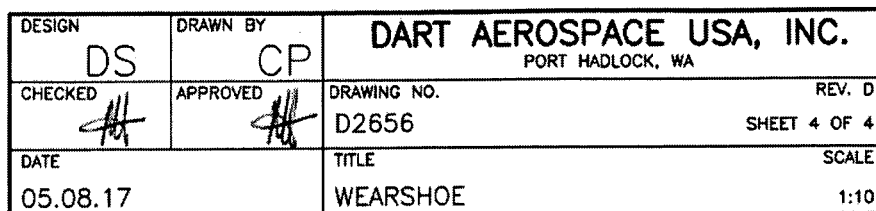
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NO. *[Handwritten]*



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05.09.06 *11*

15°

1.000

0.040 JOGGLE

LONG JOGGLE

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